

split

K1

Work Order ID 160798-2

160798

Thursday, May 04, 2017 10:55:49 AM

Item ID:	D412-630-034	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:					Stop	*NS2*
Item Name:	Folding Heli-Access-Step™ RH - Low, High & Float Gear					
Start Date:	5/15/2017	Start Qty:	4.00	Cust Item ID:		
Required Date:	6/1/2017	Req'd Qty:	4.00	Customer:		
Reference:	SCHEDULED					
Approvals:	Process Plan:	Date:	MAY 04 2017	Tooling:		
	QC:	Date:		SPC (Y/N):		

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-630	Rev O								
100	Document Control	0.00							
100	DOCUMENT CONTROL	0.00							
DC	Memo								
Doc.Control-USB or Paperwork	Photocopy bluefile & create labels per PPP D412-630-034 CHG005								
110	Small Fab	0.00							
110	Small Fab	1.64							
Small Fab	Memo								
	Assemble as per dwg D412-630 p.14								
	Coat all hardware with LPS3 rust inhibitor								
	A/R LPS3 batch: 123777								
	COAT exposed HARDWARE WITH LPS PROCYON								
	A/R LPS PROCYON BATCH: 133690								

3 17-02-11

DAS
9
9-89

~~DAS
36
9-89~~

3x

17/07/11
DAS
36
9-89

Work Order ID 160798

Thursday, May 04, 2017 10:55:49 AM

160798

Page 2

Item ID: D412-630-034 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear
 Start Date: 5/15/2017 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 6/1/2017 Req'd Qty: 4.00 *4* Customer:
 Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.08				3			 JUL 11 2017
130 *130* Packaging Packaging	Pick Kit Memo	0.00 0.00						DAS 27 9-89	MAY 10 2017
140 *140* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.12				③ 17.07.11			DAS 9 9-89

Work Order ID 160798

160798

Page 3

Thursday, May 04, 2017 10:55:49 AM

Item ID: D412-630-034 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear
 Start Date: 5/15/2017 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 6/1/2017 Req'd Qty: 4.00 *4* Customer:
 Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Packaging	0.00				3x	DAS 27 9-89		
150	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-034								
	Location: _____								
	PPP Rev: <u>fs070</u>								
160	QC21- Final Inspection - Work Order Release	0.00							
160	Memo	0.40							
QC									
Quality Control									

JUL 11 2017

17/7/12



JUL 11 2017

Picklist Print

Thursday, May 04, 2017 10:55:48 AM

Page 1

Work Order ID: 160798

160798

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 5/15/2017

Required Date: 6/1/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-08 JLM
 IPP rev B ecn1019, added D2807-041 EC verified by:DD
 IPP rev :C 11.01.06 added route seq ID DD vef:EC IPP REV:D
 13.06.07 PER CHG004 DD vef:JLM IPP REV:E 16.06.23 AS
 PER IIN REV.O DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310C8 Nut		Purchased	No			110	Each	23.0000	2	8	DAS 6 9-89		
AN310C8													
**													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST331		23							
				m135704		23							
AN3C21A Bolt		Purchased	No			110	Each	15.0000	1	4	DAS 6 9-89		
AN3C21A													
**													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST348		15							
				M135671		15							
AN44C7A Eyebolt		Purchased	No			130	Each	8.0000	1	4	DAS 6 9-89		
AN44C7A													
**													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST339		8							
				m135704		2							
				m136295		6							

DAS
9
9-89

DAS
27
9-89

Picklist Print

Page 2

Thursday, May 04, 2017 10:55:48 AM

Work Order ID: 160798

160798

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 5/15/2017

Required Date: 6/1/2017

Start Qty: 4.00

Required Qty: 4.00

AN4C10A

Purchased

No

130

Each

27.0000

1 4

**

DAS
9-89

MAY 10 2017

DAS
27
9-89

AN4C10A

BOLT

DAS
9
9-89

Location

Loc Qty

Loc Code

ST345

27

M135671

7

M136044

20

AN4C15A

Purchased

No

130

Each

41.0000

2 8

**

DAS
9-89

MAY 10 2017

DAS
27
9-89

AN4C15A

Bolt

DAS
9
9-89

Location

Loc Qty

Loc Code

FG

10

120360

10

ST343

31

M135672

1

M136301

30

AN4C6A

Purchased

No

130

Each

268.0000

1 4

**

DAS
9-89

MAY 10 2017

DAS
27
9-89

AN4C6A

Bolt

Location

Loc Qty

Loc Code

FG

14

103344

4

121657

10

OVER002

150

m137026

100

m137333

50

ST345

104

m136318

104

Thursday, May 04, 2017 10:55:48 AM

Shop Packet Print

Page 2

Picklist Print

Page 3

Thursday, May 04, 2017 10:55:48 AM

Work Order ID: 160798

160798

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 5/15/2017

Required Date: 6/1/2017

Start Qty: 4.00

Required Qty: 4.00

AN5C15A

Purchased

No

130

Each

34.0000

2 8

**

AN5C15A

Bolt

DAS
9
9-89

MAY 10 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

over003

20

M136089

20

ST337

14

M135442

14

AN8C16

Purchased

No

110

Each

9.0000

2 8

**

AN8C16

Bolt

MAY 10 2017

Location

Loc Qty

Loc Code

ST332

9

M136659

9

D2012-107

Manufactured

No

110

Each

11.0000

1 4

**

D2012-107

Clevis

MAY 10 2017

Location

Loc Qty

Loc Code

ST001

1

157180

1

WA004

10

156167

10

D2803-042

Manufactured

No

110

Each

12.0000

1 4

**

D2803-042

Bracket Assembly

MAY 10 2017

Location

Loc Qty

Loc Code

ST473

12

148431

12

Thursday, May 04, 2017 10:55:48 AM

Shop Packet Print

Page 3

Picklist Print

Page 4

Thursday, May 04, 2017 10:55:48 AM

Work Order ID: 160798

160798

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 5/15/2017

Required Date: 6/1/2017

Start Qty: 4.00

Required Qty: 4.00

D2804-042

Manufactured No

110

Each

8.0000

1

4

D2804-042

RH Step Fwd Bracket

**

MAY 10 2017

Location

Loc Qty

Loc Code

ST475

8

148424

5

151323

2

158174

1

D2806-1

Manufactured No

130

Each

19.0000

2

8

D2806-1

Bushing

**

MAY 10 2017

Location

Loc Qty

Loc Code

ST011

19

155224

19

D2806-3

Manufactured No

130

Each

21.0000

2

8

D2806-3

Bushing

**

MAY 10 2017

Location

Loc Qty

Loc Code

ST011

21

155388

21

D2807-041

Manufactured No

110

Each

14.0000

2

8

D2807-041

Prop Assembly

**

MAY 10 2017

Location

Loc Qty

Loc Code

FG

2

89606

2

ST011

12

157058

12

Thursday, May 04, 2017 10:55:48 AM

Shop Packet Print

Page 4

Picklist Print

Page 5

Thursday, May 04, 2017 10:55:48 AM

Work Order ID: 160798

160798

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 5/15/2017

Required Date: 6/1/2017

Start Qty: 4.00

Required Qty: 4.00

D2810-5

Manufactured No

130

Each

11.0000

1

4

D2810-5

Strut

**

MAY 10 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST377

11

134899

1

142838

4

153763

6

D2813

Manufactured No

110

Each

11.0000

2

8

D2813

Washer

**

MAY 10 2017

Location

Loc Qty

Loc Code

ST011

11

149366

11

D3395-1

Manufactured No

110

Each

72.0000

4

16

D3395-1

Bushing

**

MAY 10 2017

Location

Loc Qty

Loc Code

ST033

72

149467

72

D3396-1

Manufactured No

130

Each

14.0000

2

8

D3396-1

Spacer

**

MAY 10 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST033

14

149446

14

D3562-042

Manufactured No

110

Each

0.0000

1

4

D3562-042

Step Weldment

**

17/07/11

DAS
36
9-89

B157772 (3K)

Thursday, May 04, 2017 10:55:49 AM

Shop Packet Print

Page 5

Picklist Print

Page 6

Thursday, May 04, 2017 10:55:49 AM

Work Order ID: 160798

160798

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 5/15/2017

Required Date: 6/1/2017

Start Qty: 4.00

Required Qty: 4.00

D3672-15 Manufactured No 110 Each 134.0000 5 20

D3672-15

Phenolic Washer

**

MAY 10 2017

Location

Loc Qty

Loc Code

ST047

134

151784

134

20

D3672-17 Manufactured No 130 Each 231.0000 7 28

D3672-17

Phenolic Washer

**

MAY 10 2017

Location

Loc Qty

Loc Code

ST047

231

148074

7

150866

224

7

21

MAY 10 2017

D3672-19 Manufactured No 110 Each 168.0000 4 16

D3672-19

Phenolic Washer

**

Location

Loc Qty

Loc Code

ST050

168

148075

168

16

D3672-5 Manufactured No 130 Each 675.0000 7 28

D3672-5

Washer, Phenolic

**

MAY 10 2017

Location

Loc Qty

Loc Code

FG

8

44679

8

ST047

167

50354

167

ST051A

500

153354

500

28

Thursday, May 04, 2017 10:55:49 AM

Shop Packet Print

Page 6

Picklist Print

Thursday, May 04, 2017 10:55:49 AM

Page 7

Work Order ID: 160798

160798

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 5/15/2017

Required Date: 6/1/2017

Start Qty: 4.00

Required Qty: 4.00

D3672-7

Manufactured No

110

Each

843.0000

4

16

D3672-7

Washer, Phenolic

MAY 10 2017

Location

Loc Qty

Loc Code

FG

21

129987

6

133986

15

ST047

322

153039

322

ST051A

500

157442

500

16

MS21043-3

Purchased No

110

Each

524.0000

4

16

MS21043-3

Nut

MAY 10 2017

DAS
6
9-83

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

176

m130673

11

m136182

165

GA

199

m133990

27

m136182

172

ST304

69

m131340

69

16

Picklist Print

Page 8

Thursday, May 04, 2017 10:55:49 AM

Work Order ID: 160798

160798

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 5/15/2017

Required Date: 6/1/2017

Start Qty: 4.00

Required Qty: 4.00

MS21043-4 Purchased No 130 Each 930.0000 4 16

MS21043-4

Nut

DAS
9
9-89

Location	Loc Qty	Loc Code
FG	40	
104603	40	
GA	7	
m132803	7	
ST302	883	
m136406	2	
m136983	281	
m137361	300	
m137371	300	

MAY 10 2017

DAS
27
9-89

MS21043-5 Purchased No 130 Each 187.0000 3 12

MS21043-5

Nut

DAS
9
9-89

Location	Loc Qty	Loc Code
FG	20	
101418	20	
GA	71	
116548	71	
ST302	96	
m137361	96	

MAY 10 2017

DAS
27
9-89

MS24665-302 Purchased No 110 Each 69.0000 2 8

MS24665-302

Cotter Pin

Location	Loc Qty	Loc Code
ST288	69	
m135672	69	

MAY 10 2017

Thursday, May 04, 2017 10:55:49 AM

Shop Packet Print

Page 8

Picklist Print

Page 9

Thursday, May 04, 2017 10:55:49 AM

Work Order ID: 160798

160798

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 5/15/2017

Required Date: 6/1/2017

Start Qty: 4.00

Required Qty: 4.00

MS24693-C280

Purchased

No

110

Each

8.0000

2

8

MS24693-C280******

SCREW

LocationLoc QtyLoc Code

ST287

8

m135672

8

MS24693-C285

Purchased

No

110

Each

25.0000

1

4

MS24693-C285******

Screw

LocationLoc QtyLoc Code

ST287

25

m135704

25

MAY 10 2017

MAY 10 2017

Thursday, May 04, 2017 10:55:49 AM

Shop Packet Print

Page 9

Work Order ID 160/98

Thursday, May 04, 2017 10:55:49 AM

160/98

Item ID: D412-630-034	Accept	*N900040100*	Setup Start *NS1*
Revision ID:			Stop *NS2*
Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear			
Start Date: 5/15/2017	Start Qty: 4.00 *4*	Cust Item ID:	
Required Date: 6/1/2017	Req'd Qty: 4.00 *4*	Customer:	
Reference: SCHEDULED			
Approvals: Process Plan: 	Date: MAY 04 2017	Tooling: _____	Run Start *NR1*
QC: _____	Date: _____	SPC (Y/N): _____	Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-630	Rev O								
100	Document Control .	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & create labels per PPP D412-630-034 CHG005								
110		0.00							
110	Small Fab								
Small Fab	Memo	1.64							
Small Fab	Assemble as per dwg D412-630 p.14								
	Coat all hardware with LPS3 rust inhibitor								
	A/R LPS3 batch: _____								
	COAT exposed HARDWARE WITH LPS PROCYON .								
	A/R LPS PROCYON BATCH: _____								

CB

3

MAY 08 2017



Department of Transport

Supplemental Type Certificate

This approval is issued to:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario
Canada K6A 1K7

Number: SH96-69

Issue No.: 7

Approval Date: May 29, 1996

Issue Date: December 22, 2005

Responsible Office:

Ontario

Aircraft/Engine Type or Model:

BELL 205A, 205A-1, 205B, 212, 214B, 214B-1, 412, 412 CF,
412 EP

Canadian Type Certificate or Equivalent:

BELL 205A, 205A-1 H1SW
BELL 205B H-104
BELL 214B, 214B-1 H-80
BELL 212, 412, 412 CF, 412 EP H-86

Description of Type Design Change:

Heli-Access-Step

**Installation/Operating Data,
Required Equipment and Limitations:**

Manufacture of the Heli-Access-Step must be done in accordance with Dart Aerospace Ltd. Master Document List, MDL-412-630, Revision B, approved Dec 15, 2005, or later approved revisions.

Installation of the Heli-Access-Step must be done in accordance with Dart Aerospace Ltd. Installation Instruction D412-630, Revision J, approved Dec 08, 2005, or later approved revisions.

Maintenance of the Heli-Access-Step must be done in accordance with Dart Aerospace Ltd. Instructions for Continued Airworthiness, ICA-D412-630, Revision 1, Transport Canada accepted Dec 22 2005, or later Transport Canada accepted revisions.

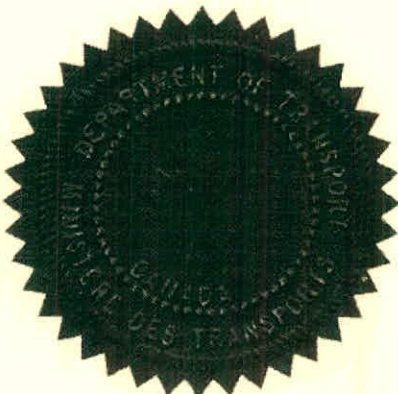
Operations with the Heli-Access-Step installed must be in accordance with Dart Aerospace Ltd. Flight Manual Supplement FMS-D412-630, Revision D, Transport Canada approved Dec 22 2005, or later Transport Canada approved revisions.

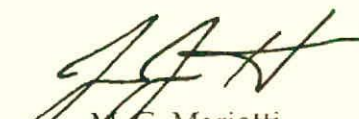
Basis of Certification:

The basis of certification for this modification was FAR 29, up to and including Amendment 29-47

-- End --

Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated will not adversely affect the airworthiness of the modified product.




M. G. Mariotti
For Minister of Transport

REFERENCE ONLY

DAS
9
3-89

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
7	7			D3672-5	WASHER (OR NAS1515H5)
		4	4	D3672-7	WASHER (OR NAS1515H5L)
		5	5	D3672-15	WASHER (OR NAS1515H3)
7	7			D3672-17	WASHER (OR NAS1515H4)
		4	4	D3672-19	WASHER (OR NAS1515H8)
		1	1	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C65)
		1	1	MS24693-C285	SCREW (OR MS24694-C76)

REFERENCE UNIT